

Date: Tuesday, 13/01/2009 2:03:51 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG  
 Job Number : 44726  
 Estimate Number : 13267  
 P.O. Number :  
 This Issue : 13/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : // Type : MACHINED PARTS  
 Previous Run : 38837  
 Written By : *[Signature]* 09-01-13  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 08-04-16 JLM Verified By:EC

Part Number : D37071  
 Drawing Number : UNDER REVIEW  
 Project Number : N/A  
 Drawing Revision : U/R  
 Material :  
 Due Date : 20/01/2009 Qty: 6 Um: Each

## Additional Product

PRELIMINARY ISSUE



Job Number:



*[Signature]* 09-01-14  
 09-01-14

Seq. #: Machine Or Operation: Description :

1.0 MDLRLNB1250X2500 Delrin Bar 1.250"X 2.500"



Comment: Qty.: 0.2363 Ft(s)/Unit Total : 1.4175 Ft(s)

Delrin Bar 1.250"X 2.500"

BATCH: *M107758**[Signature]* 09/01/13

6

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 2.700" long

*[Signature]* 09/01/13

6

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1 HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA737 Rev: *AA* & Dwg D3707 Rev: *U/R*

2-Deburr per dwg D3707 and countersink .5625" ON DRILL PRESS

*[Signature]* J.F. 09/01/15 (6)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*[Signature]* J.F. 09/01/15 (6)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*[Signature]* 09-01-15 (6)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 44726

Part Number: D37071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*09.01.15*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/17*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE *09.01.15* AUTH *u*

RELEASED *J* DATE *09.02.17*

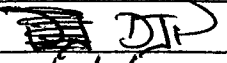

*MF 09-01-15*

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	44726
<b>Description:</b> Mounting Lug		<b>Part Number:</b>	D 3707-1
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>	

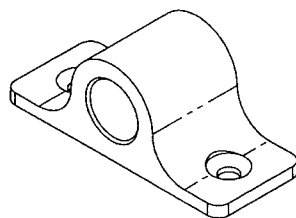
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

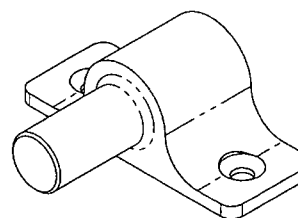
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	$\pm 0.030$	2.500	✓			
1.750	$\pm 0.010$	1.750	✓			
0.38	$\pm 0.030$	0.374	✓			
0.500	$\pm 0.010$	0.495	✓			
1.00	$\pm 0.030$	0.998	✓			
$\phi 0.385 \times 100^\circ$	$\pm 0.010 / \pm 1/2^\circ$	$0.380 \times 100^\circ$	✓			2 PL
$\phi 0.201$	$+0.005 / -0.001$	0.201	✓			Thru
$0.03 \times 45^\circ$	$\pm 0.030 / \pm 1/2^\circ$	$.03 \times 45^\circ$	✓			Chamfer 2 PL
R0.13	$\pm 0.030$	.125	✓			2 PL
R0.48	$\pm 0.030$	.480	✓			
0.98	$\pm 0.030$	.9745	✓			REF
0.500	$\pm 0.010$	0.500	✓			
1.250	$\pm 0.010$	1.250	✓			
0.125	$\pm 0.010$	0.125	✓			
R0.38	$\pm 0.030$	.38	✓			
$\phi 0.563$	$+0.001 / -0.000$	.561	✓			Thru

<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/01/14	<b>Date:</b>	09-01-15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



**D3707-1 MOUNTING LUG**



**D3707-3 MOUNTING LUG**

44726

RELEASED  
9/6/05 MB

**NOTES:**

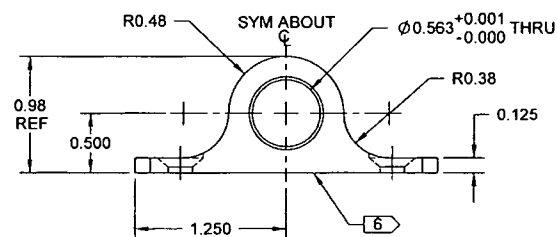
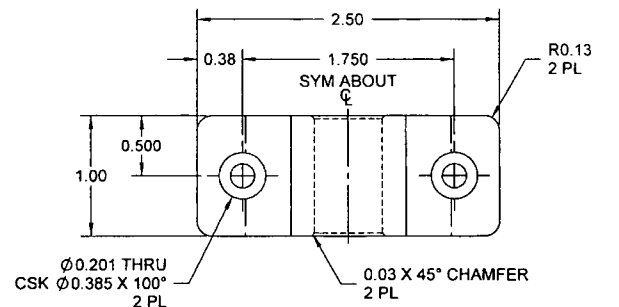
- 1) MATERIAL: BLACK ACETRON GP ACETAL  
(REF DART SPEC M-DELRIN-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE WITH DART P/N "D3707-X" USING VIBRATING STYLUS
- 7) WEIGHT: D3707-1 = 0.04 lbs APPROX  
D3707-3 = 0.07 lbs APPROX

B	UPDATED NOTE 1 (ZN A8-1)	MB	08.08.22
A	NEW ISSUE	MB	08.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.22		

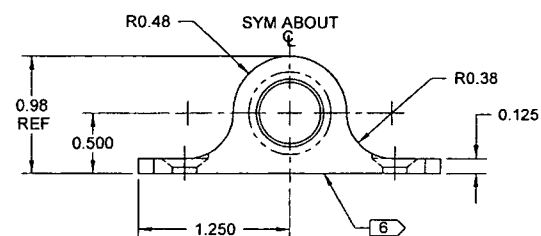
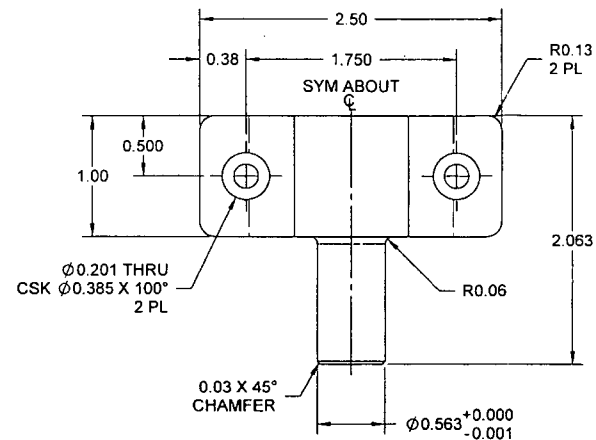
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3707** REV. B  
SHEET 1 OF 2  
TITLE **MOUNTING LUG** SCALE NTS

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**D3707-1 MOUNTING LUG**



**D3707-3 MOUNTING LUG**

**RELEASED**  
69/02/05/14/1

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3707</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>MOUNTING LUG</b>	NTS
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